

Date: Thursday, 6/15/2006 1:52:18 PM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|-------------------------------------|----------------|--|--|--|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | SADDLE FITTING, AFT (OUTBOARD/INBOARD) | | |
| Job Number | 27598 | Part Number | D2574 | | |
| Estimate Number | 10534 | Drawing Number | D2574 REV E | | |
| P.O. Number | N/A | Project Number | N/A | | |
| This Issue | 6/15/2006 | S.O. No. | N/A | | |
| Prsht Rev. | NC | Type | MACHINED PARTS | | |
| First Issue | N/A | | | | |
| Previous Run | 27059 | Material | N/A | | |
| Written By | <i>See comment below</i> | | | | |
| Checked & Approved By | <i>JG 06.15.06</i> | | | | |
| Comment | Est Rev: I As Per RevE 06-01-27 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|-------------------------|--|
| 1.0 | D6101005 | 7075-T7351 8.25X5.0X2.5 | |

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: *823940**T3 24069 x5**J.G. 06/06/19 x12*

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No: *21598* Double check by: *SD*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

J.G./Ep 06/06/25 x 12

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

J.G./Ep 06/06/25 x 12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G./Ep 06/06/25 x 12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 

Date: 06/06/13

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/15/2006 1:52:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27598

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ML 06/06/26 12

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H.M 06-06-28

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.m 06-06-29

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PL 06/06/29 12

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 480

06-06-30

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/06/30 12

Job Completion



U 06/06/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

| | | |
|----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 27598 |
| Description: Saddle, Aft Inboard | Part Number: | D2574 |
| Inspection Dwg: D2574 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.441 | 0.441 | 0.441 | 0.441 | | |
| B | 1.745 | 1.755 | | 1.749 | 1.748 | 1.747 | 1.747 | | |
| C | 3.495 | 3.505 | | 3.498 | 3.499 | 3.497 | 3.496 | | |
| D | 1.745 | 1.755 | | 1.747 | 1.748 | 1.747 | 1.748 | | |
| E | 7.990 | 8.010 | | 8.004 | 8.003 | 8.002 | 8.003 | | |
| F | 0.490 | 0.510 | | 0.492 | 0.493 | 0.494 | 0.495 | | |
| G | 0.257 | 0.262 | DT8683 | 0.257 | 0.257 | 0.257 | 0.257 | | |
| H | 0.375 | 0.380 | DT8684 | 0.377 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.497 | 0.498 | 0.497 | 0.498 | | |
| J | 1.174 | 1.184 | | 1.177 | 1.177 | 1.177 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.566 | 0.566 | 0.567 | 0.567 | | |
| L | 1.174 | 1.184 | | 1.177 | 1.177 | 1.177 | 1.177 | | |
| M | 1.365 | 1.375 | | 1.368 | 1.368 | 1.367 | 1.369 | | |
| N | 2.495 | 2.505 | | 2.497 | 2.498 | 2.497 | 2.498 | | |
| O | 4.119 | 4.129 | | 4.121 | 4.120 | 4.121 | 4.120 | | |
| P | 0.115 | 0.135 | | 0.125 | 0.126 | 0.127 | 0.129 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.253 | 0.254 | 0.254 | 0.255 | | |
| S | 0.115 | 0.135 | | 0.119 | 0.119 | 0.120 | 0.122 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.235 | 0.235 | 0.235 | 0.236 | | |
| W | 0.115 | 0.135 | | 0.121 | 0.120 | 0.122 | 0.124 | | |
| X | 0.307 | 0.312 | | 0.310 | 0.310 | 0.310 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.366 | 0.364 | 0.367 | 0.368 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.675 | 0.634 | 0.630 | 0.631 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.245 | 0.244 | 0.241 | 0.240 | | |
| AE | 1.500 | 1.520 | | 1.513 | 1.514 | 1.512 | 1.513 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.245 | 0.246 | 0.247 | 0.248 | | |
| AI | 2.000 | 2.020 | | NA | NA | NA | NA | | |
| AJ | 0.023 | 0.043 | | 0.038 | 0.030 | 0.030 | 0.030 | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|----------|-------------|----------|
| Measured by: | SP/J.G | Audited by: | SMC |
| Date: | 06/06/23 | Date: | 06/06/26 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | SP/J.G |

| | | |
|----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 27598 |
| Description: Saddle, Aft Inboard | Part Number: | D2574 |
| Inspection Dwg: D2574 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | | |
|----------------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|--|
| | | | | 1 | 2 | 3 | 4 | By | |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.440 | 0.440 | 0.440 | | |
| B | 1.745 | 1.755 | | 1.747 | 1.747 | 1.746 | 1.746 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.499 | 3.496 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.748 | 1.747 | 1.746 | 1.746 | | |
| E | 7.990 | 8.010 | | 8.002 | 8.000 | 8.003 | 8.002 | | |
| F | 0.490 | 0.510 | | 0.499 | 0.499 | 0.496 | 0.498 | | |
| G | 0.257 | 0.262 | DT8683 | 0.258 | 0.258 | 0.258 | 0.258 | | |
| H | 0.375 | 0.380 | DT8684 | 0.376 | 0.376 | 0.376 | 0.376 | | |
| I | 0.490 | 0.510 | | 0.501 | 0.499 | 0.498 | 0.493 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.174 | 1.174 | | |
| K | 0.558 | 0.578 | | 0.569 | 0.568 | 0.566 | 0.562 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.174 | 1.174 | | |
| M | 1.365 | 1.375 | | 1.371 | 1.371 | 1.366 | 1.368 | | |
| N | 2.495 | 2.505 | | 2.498 | 2.495 | 2.497 | 2.496 | | |
| O | 4.119 | 4.129 | | 4.121 | 4.122 | 4.119 | 4.121 | | |
| P | 0.115 | 0.135 | | 0.130 | 0.129 | 0.124 | 0.123 | | |
| Q | 0.115 | 0.135 | | 0.129 | 0.130 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.249 | 0.250 | 0.249 | 0.251 | | |
| S | 0.115 | 0.135 | | 0.128 | 0.127 | 0.119 | 0.119 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.231 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.241 | 0.244 | 0.233 | 0.233 | | |
| W | 0.115 | 0.135 | | 0.121 | 0.122 | 0.125 | 0.126 | | |
| X | 0.307 | 0.312 | | 0.310 | 0.310 | 0.310 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.761 | 0.761 | 0.761 | 0.761 | | |
| Z | 0.352 | 0.372 | | 0.364 | 0.364 | 0.362 | 0.364 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.628 | 0.629 | 0.625 | 0.625 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.250 | 0.247 | 0.242 | 0.244 | | |
| AE | 1.500 | 1.520 | | 1.511 | 1.512 | 1.513 | 1.512 | | |
| AF | 0.115 | 0.135 | | 0.120 | 0.121 | 0.125 | 0.125 | | |
| AG | 0.240 | 0.280 | | 0.249 | 0.248 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.251 | 0.251 | 0.245 | 0.244 | | |
| AI | 2.000 | 2.020 | | N/A | N/A | N/A | N/A | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|------------|-------------|------------|
| Measured by: | J.G / CP | Audited by: | TM |
| Date: | 06/06/2016 | Date: | 06/06/2016 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | SG |

| | | |
|----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 27598 |
| Description: Saddle, Aft Inboard | Part Number: | D2574 |
| Inspection Dwg: D2574 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|-----|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.446 | 0.441 | 0.441 | 0.441 | | |
| B | 1.745 | 1.755 | | 1.745 | 1.749 | 1.747 | 1.749 | | |
| C | 3.495 | 3.505 | | 3.497 | 3.497 | 3.500 | 3.498 | | |
| D | 1.745 | 1.755 | | 1.745 | 1.749 | 1.747 | 1.749 | | |
| E | 7.990 | 8.010 | | 8.003 | 8.002 | 8.003 | 8.002 | | |
| F | 0.490 | 0.510 | | 0.498 | 0.502 | 0.502 | 0.502 | | |
| G | 0.257 | 0.262 | DT8683 | 0.258 | 0.259 | 0.259 | 0.259 | | |
| H | 0.375 | 0.380 | DT8684 | 0.376 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.496 | 0.498 | 0.498 | 0.495 | | |
| J | 1.174 | 1.184 | | 1.176 | 1.176 | 1.179 | 1.176 | | |
| K | 0.558 | 0.578 | | 0.561 | 0.564 | 0.565 | 0.562 | | |
| L | 1.174 | 1.184 | | 1.176 | 1.176 | 1.179 | 1.176 | | |
| M | 1.365 | 1.375 | | 1.366 | 1.369 | 1.370 | 1.369 | | |
| N | 2.495 | 2.505 | | 2.496 | 2.497 | 2.497 | 2.498 | | |
| O | 4.119 | 4.129 | | 4.120 | 4.123 | 4.126 | 4.123 | | |
| P | 0.115 | 0.135 | | 0.124 | 0.122 | 0.124 | 0.126 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.251 | 0.250 | 0.250 | 0.253 | | |
| S | 0.115 | 0.135 | | 0.121 | 0.117 | 0.117 | 0.118 | | |
| T | 0.178 | 0.198 | | 0.180 | 0.180 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.235 | 0.234 | 0.234 | 0.238 | | |
| W | 0.115 | 0.135 | | 0.127 | 0.123 | 0.121 | 0.126 | | |
| X | 0.307 | 0.312 | | 0.310 | 0.310 | 0.310 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.365 | 0.363 | 0.365 | 0.370 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.502 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.621 | 0.627 | 0.627 | 0.626 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.245 | 0.245 | 0.244 | 0.243 | | |
| AE | 1.500 | 1.520 | | 1.511 | 1.511 | 1.511 | 1.514 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.245 | 0.249 | 0.245 | 0.245 | | |
| AI | 2.000 | 2.020 | | N/A | N/A | N/A | N/A | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.030 | 0.030 | 0.030 | | |

Accept/Reject

| | | | |
|--------------|----------|-------------|----------|
| Measured by: | EP | Audited by: | gme |
| Date: | 06/06/25 | Date: | 06/06/26 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | gme |

